

Work Order ID 51410

August 21, 2009 10:17:39 AM



Page 1

Item ID: D3171-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 8/21/09 Start Qty: 20.00



Cust Item ID:

Required Date: 8/27/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CZ

Date: 8/18/09 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3171	Rev A
-------	-------

26

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3171-1 Dwg Rev: A Prog Rev: A 12-
Deburr if necessary

B 9-8-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

H3 9-8-17

26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> 8/25/09/25

counted
(26) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51410

August 21, 2009 10:17:39 AM

Page 2

Item ID: D3171-1

Accept

Revision ID: A

Item Name: Angle

Setup Start

Stop

Start Date: 8/21/09

Start Qty: 20.00

Required Date: 8/27/09

Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Deburr if necessary

0.00

0.00

M-H 09/08/25

(26X)

140



Brake NC

Brake NC

NC BRAKE

Memo

Bend as per Dwg D31711 Tumble

0.00

0.00

SB 09/08/26

26

B 9-8-27

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=> 09/08/27

counted
(26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51410

August 21, 2009 10:17:39 AM

Page 3

Item ID: D3171-1

Revision ID: A

Item Name: Angle

Start Date: 8/21/09 Start Qty: 20.00

Required Date: 8/27/09 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 69

0.00



Packaging

Memo

0.00

Packaging

9/8/28

(262) SL

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/31 HJ

PL 09-8-28

Picklist Print

August 21, 2009 10:17:39 AM

Page 1

Work Order ID: 51410

Parent Item: D3171-1RevA

Parent Item Name: Angle

Comments:

Start Date: 8/21/09

Required Date: 8/27/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	206.3330	0.4337			



304/316 Sheet .063

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	206.3329737	
106860	16.018	
111924	33.0549737	
112290	157.26	

112290

HB 9-8-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

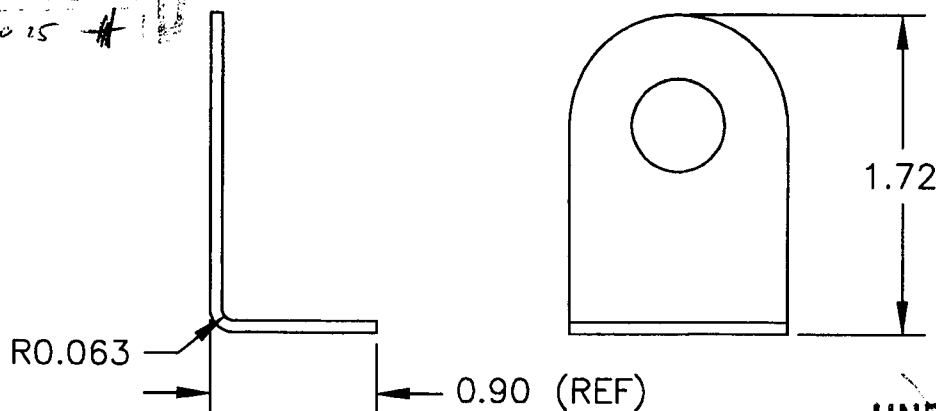
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3171	REV. A SHEET 1 OF 1
DATE 02.10.08		TITLE ANGLE	SCALE 1:1
A	02.10.08	NEW ISSUE	

RELEASED
02.10.25 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 5141064

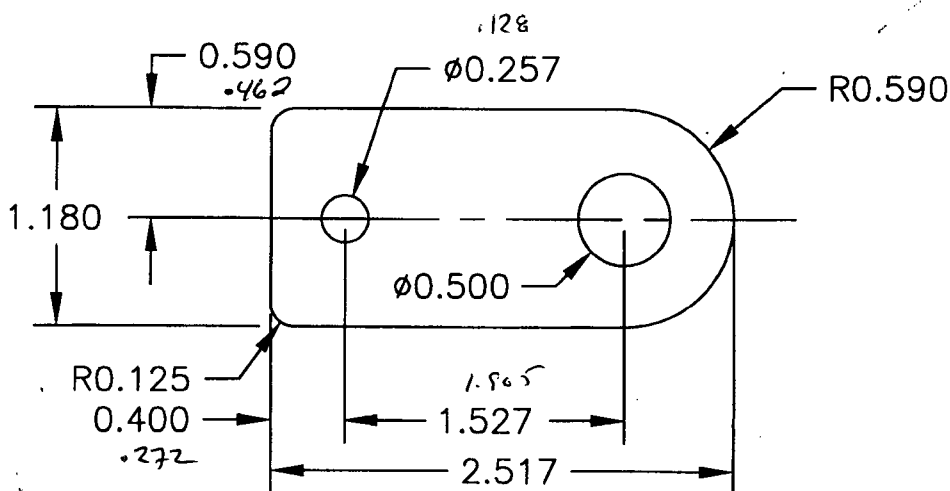
D3171-1 ANGLE

~~UNDER REVIEW~~

~~57.06.02 CB~~

~~adding -3~~

OK
CB
-3 not
being
used



D3171-1 ANGLE FLAT PATTERN

NOTES

- 1) MATERIAL: AISI 304/316 ANNEALED SS SHEET 0.063 THICK
PER MIL-S-5019 (REF. DART SPEC. M304S16GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.